

Work Order ID 72886

Wednesday, August 17, 2011 2:43:03 PM

Page 1

Item ID: D2932-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Saddle LH Out, 206

Start Date: 8/17/2011 Start Qty: 4.00

Cust Item ID:

Required Date: 8/25/2011 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan:

Date: 11-08-17

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2932

Rev C

100

0.00



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 13-Machine Step No 2 of Folio and visually inspect as per

0.00

and B.A 11/08/25

5

φ

110

0.00



Mill Conv

Conventional Milling Machine.

CONVENTIONAL MILLING MACHINE

Memo

Machine Keyway and inspect per attached dimension sheet

0.00

B.A 11/08/25

5

φ

120

0.00



QC

Quality Control

QC1- Inspect dimensions to dimension sheet

Memo

0.00

and B.A 11/08/25

5

φ

W/O: 72886		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: DZ832-1 PAR #: N/A Fault Category: Machining NCR: Yes No DQA: 11 Date: 11.09.02
 Resolution: Good as is Disposition: Use Good as is QA: N/C Closed: ck Date: 11/09/02
11-5603 acceptable

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11.08.29	100	Chamber tool went 20.025" too deep on lower edge of skid bolt profile. R.C. operator Error LOA	JP 11.08.29 Q5/042	Acceptable. Edge only subject to lower downward loads. Not critical	and 11/08/29	S 11/08/29	JP 11.08.29 Q5/042	S 11/08/29
		(Photo + Drawing are close)						

NOTE: Date & initial all entries

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Wednesday, August 17, 2011 2:43:03 PM



Page 2

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Cust Item ID:

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

SL 11-08-29



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

5x Ø m-11/08/30

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

2:30

320°F

3:00

5x Ø m-11/08/30

MN7745

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72886

Wednesday, August 17, 2011 2:43:03 PM

Page 3

Item ID: D2932-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Saddle LH Out, 206

Start Date: 8/17/2011 Start Qty: 4.00

Cust Item ID:

Required Date: 8/25/2011 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

5 of 11 11-08-30

170

Identify as per dwg & Stock Location: ST 428 0.00



Packaging

Memo

0.00

Packaging

5x 11-08-30 ✓

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11-08-31 MF 11-08-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, August 17, 2011 2:43:08 PM

Page 1

Work Order ID: 72886



Parent Item: D2932-1



Parent Item Name: Saddle LH Out, 206

Start Date: 8/17/2011

Required Date: 8/25/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: BU100.06.26 New DWG rev, (mpp 2069) LIEC
IPP Rev: C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003 		Manufactured	No			100	Each	40.0000	1	4			

Saddle Billet, 7075

Location

Loc Qty

Loc Code

MAT040

20

72226

20

MAT44

20

72226

20

4.0
+ 1.0

B.A 11/08/24

B.A 11/08/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	72886
Description: 206 Saddle, Outboard, Left side		Part Number:	D2932-1
Inspection Dwg: D2932 Rev. C		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.103	.110	.106	.103		.104
B	0.100	0.140		.111	.104	0.101	.110		.109
C	0.100	0.140		.113	.115	.114	.113		.115
D	0.210	0.230		.217	.220	.224	.220		.222
E	1.245	1.255		1.250	1.250	1.250	1.250		1.250
F	1.245	1.255		1.250	1.250	1.250	1.250		1.250
G	2.495	2.505		2.500	2.500	2.500	2.500		2.500
H	0.510	0.515		0.512	0.512	0.512	0.512		.512
I	1.572	1.582		1.578	1.578	1.578	1.578		1.578
J	2.495	2.505		2.500	2.500	2.500	2.500		2.500
K	0.257	0.262		.258	.258	0.258	0.258		.258
L	0.312	0.317		.314	0.314	0.314	0.314		.314
M	0.235	0.240		.237	.237	.237	.237		.237
N	0.100	0.140		.120	.112	.113	.109		.112
O	0.540	0.560		.550	.550	.550	.550		.550
P	0.490	0.510		.500	.499	.503	.500		.501
Q	3.715	3.725		3.720	3.720	3.720	3.720		3.720
R	2.470	2.510		2.490	2.490	2.490	2.490		2.490
S	0.240	0.270		.247	.251	.247	.251		.250
T	0.100	0.180		.135	0.135	0.135	0.135		.135
U	1.625	1.635		1.630	1.630	1.630	1.630		1.630
V	1.362	1.372		1.367	1.367	1.367	1.367		1.367
W	0.316	0.321		.316	.316	0.316	0.316		.316
X	1.125	1.145		1.133	1.132	1.140	1.132		1.135
Y	1.565	1.585		1.572	1.570	1.578	1.570		1.571
Z	0.178	0.198		.188	.188	0.188	0.188		.188
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	AM / H.A.
Date:	11/08/24 / 11/08/25

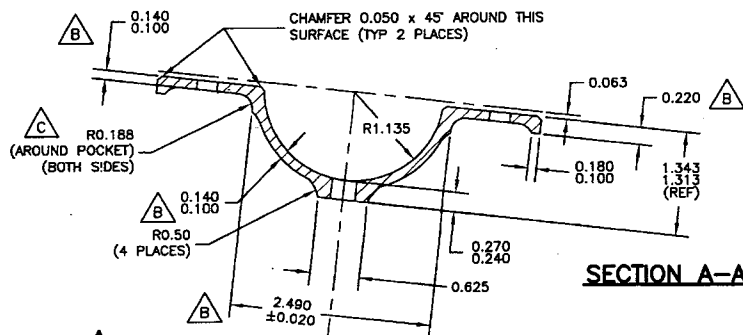
Audited by:	X
Date:	11-08-24

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

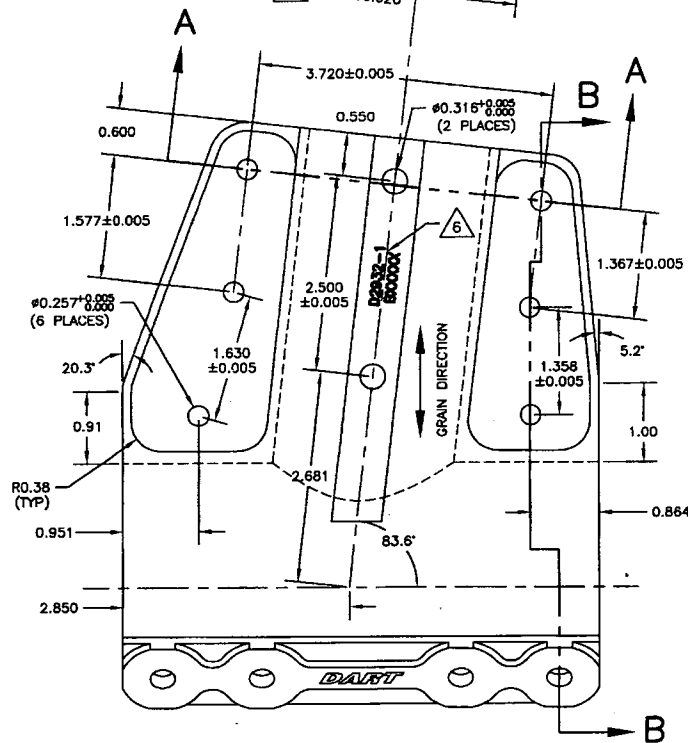
SHOP COPY
RETURN TO:

ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *22885*
11-08-17

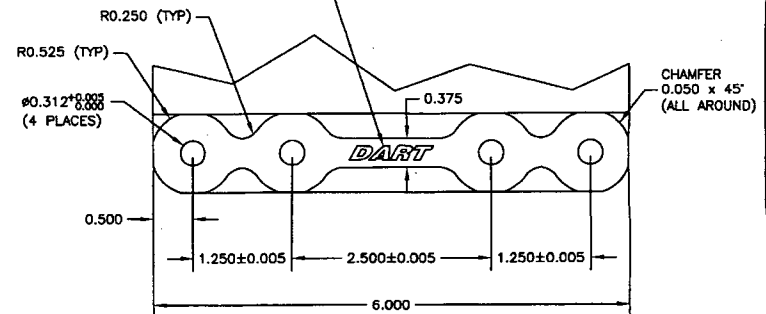
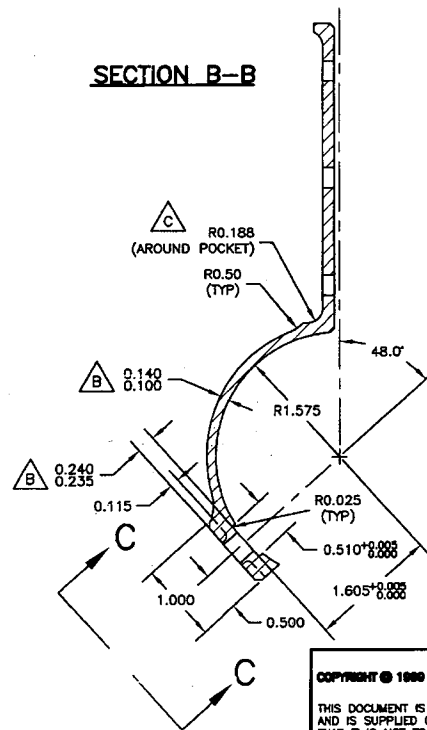
ENGRAVE DART LOGO TO MAX DEPTH
OF 0.005 WITH MIN RAD 0.250



SECTION A-A



SECTION B-B



VIEW C-C

D2932-1 LH SADDLE (SHOWN)
D2932-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	<i>PH</i>	DRAWN BY: <i>CB</i>
CHECKED	<i>PH</i>	APPROVED: <i>PH</i>
DATE	06.11.09	TITLE: SADDLE OUTSIDE
		DRAWING NO. D2932
		REV. C SHEET 1 OF 1
		SCALE 2:3

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